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D4021-5

Job Sheet 194810

DAS
21
9-89



Part No: D4021-5

Job Qty: 40 pcs

Part Name: Blanking Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/8/19

Job Tracking No:

Due Date: 6/26/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEET 2 IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB DD 10.04.20 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	40 pcs		6/26/19	0.00	1.88	Waterjet - Flow		06/19/06/11
120	QC 8	40 pcs		6/26/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
130	Powdercoat - 2 White Gl(S)-B4B	40 pcs		6/26/19	0.00	0.67	Powdercoat - 1 - B4B		
							Powdercoat - 2 - B4B		BE 819-06-12
							Powdercoat - 3 - B4B		
							Powdercoat - 4 - B4B		
135	QC 3	40		6/26/19	0.00	0.00	QC 3 - 10		

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pcs						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	DAS
						QC 3 - 40	JUN 13 2019 40
						QC 3 - 19	9-89
						QC 3 - 43	
						QC 3 - 24	
140 Packaging 3-1 - Stock - B4B	40 pcs	6/26/19	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	FP00 JUN 13 2019
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 -	

				B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	40 pcs	6/26/19	0.00 0.00	QC 21 - SA - 21	DWG
				QC 21 - SA - 70	21
				QC 21 - SA - 53	2-53

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Part Op 100 - Cut as per dwg D4021
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel)
 135 - (QC3- Inspect Part Finish)
 140 - (Identify as per dwg & Stock Location: _____)
 150 - (QC21- Final Inspection - Work Order Release)

START: 2:00 TEMP 320° FINISH: 2:30

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	2.4880 sf (.0622 ea)	100-Waterjet - Flow - 1	5158674

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	2	233	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Blanking Plate	0.194Inches + 0.005 - 0.001	0.199 0.193	Diameter	
2	Blanking Plate	3.500Inches ± 0.030	3.530 3.470		
3	Blanking Plate	2.560Inches ± 0.030	2.590 2.530		
4	Blanking Plate	0.810Inches ± 0.030	0.840 0.780		
5	Blanking Plate	0.060Inches ± 0.010	0.070 0.050		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S188988



Part: D4021-5

Job No: 194810

Serial No/Batch: S188988

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/11/19